

Split

23384

D3262-041

ZO

Page 1 of 1

5/25  
DART AEROSPACE LTD

Description: Fuel Purge Canister

Dwg: D3262 Rev. B

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) D3262-041 consists of (1) D3262-041 and (1) D3262-041	JL	05.05.20	ZO
2	MV	Cut (2) blanks per (1) D3262-041 Cut blanks: 8.000" x 0.500" x 5.400" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) (M6061T6B0.500x0.500)	Batch		
3	MV	Machine as per Folia FA457 and Dwg D3262-041	JL	05/03/20	ZO
4	QC2	Identify for D3262-1	JL	05/03/20	ZO
5	QC8	Machine as per Folia FA457 and Dwg D3262-041	JL	05/03/20	ZO
6	MV	Inspect parts as they come off the CNC machine	JL	05/03/20	ZO
7	MV	Second check	JL	05/03/20	ZO
8	MV	Deburr	JL	05/03/20	ZO
9	WA	Cut D3262-1 to length as per Dwg D3262-041 Material: 6061-T6 / QQ-A-200/8 or 225/8) 5.00 DE + 5.125" wall (M6061T6B0.500W125) Identify as D3262-1	KJL	05/03/20	ZO
10	WA	Weld canister assembly as per Dwg D3262 using CT3739 to align fillings	KJL	05/03/20	ZO
11	QC915	Pick: Qty Part Number A/R	Batch		
12	QC5	Inspect weld and walk to Step 8	Z/Mos65/03	05/03/20	ZO
13	FP	Pressurize canister to 10 psi and submerge under water and check for leaks as per Dwg D3262.	Z/Mos65/03	06.05.03	3
14	FP	Chemical Conversion Coat as per QSI 005.4.1	Z/Mos65/03	06.05.03	3
15	ST	Powder Coat Gloss White (Ref. 4.3.5.1) as per QSI 005.4.3 Ensure to mask threads	Z/Mos65/03	06.05.04	3
16	QC3	Inspect Powder Coat	Z/Mos65/03	06.05.04	3
17	ST	Identify with Dart part number and batch number using a fine point permanent ink marker, then Stock	Z/Mos65/03	06.05.04	3
18	AC	Cost / part:	Z/Mos65/03	06.05.05	3
19	DC	Close W/O Inspect Level 21	Z/Mos65/03	06.05.05	3

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	
B	04.09.29	Added Steps 10-12; changed Step 16	KJ/JLM	
C	05.03.10	Removed P/O for liquid penetrant inspection	KJ/JLM	

Jeff

Date: Monday, 12/12/2005 8:31:51 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	: FUEL PURGE CANISTER		
<b>Job Number</b>	: 23284					
<b>Estimate Number</b>	: 10440					
<b>P.O. Number</b>	:			<b>Part Number</b>	: D3262041	
<b>This Issue</b>	: 12/12/2005		<b>S.O. No.</b>	: D3262 REV B		
<b>Prsht Rev.</b>	: NC			<b>Project Number</b>	:	
<b>First Issue</b>	: 11/14/2005		<b>Type</b>	: MACHINED PARTS		
<b>Previous Run</b>	:			<b>Drawing Revision</b>	: B	
<b>Written By</b>	:			<b>Material</b>	:	
<b>Checked &amp; Approved By</b>	:			<b>Due Date</b>	: 11/30/2005	
<b>Comment</b>	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM			<b>Qty:</b>	3	<b>Um:</b> Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	23284A	FUEL PURGE CANISTER	
<b>Comment:</b> Sub-Component FUEL PURGE CANISTER			
2.0	23284B	FUEL PURGE CANISTER	
<b>Comment:</b> Sub-Component FUEL PURGE CANISTER			
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
<b>Comment:</b> LARGE FABRICATION RESOURCE 1 Weld canister assembly as per Dwg D3262 using DT8739 to align fillings			
Pick: Qty Part Number Description Batch A/R Aluminum Rod			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
<b>Comment:</b> INSPECT WORK TO CURRENT STEP 1-Inspect weld and work to Step 8 2-Pressurize canister to 10 psi and submerge under water and check for leaks as per Dwg D3262.			
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
<b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1			

Date: Monday, 12/12/2005 8:31:52 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 23284

Part Number: D3262041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Monday, 12/12/2005 8:31:55 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	FUEL PURGE CANISTER		
<b>Job Number</b>	23284A			<b>Part Number</b>	D32621		
<b>Estimate Number</b>	10441			<b>Drawing Number</b>	D3262 REV B		
<b>P.O. Number</b>				<b>Project Number</b>			
<b>This Issue</b>	12/12/2005 <b>S.O. No.</b> :			<b>Drawing Revision</b>	B		
<b>Prsht Rev.</b>	NC			<b>Material</b>			
<b>First Issue</b>	11/14/2005	<b>Type</b>	MACHINED PARTS	<b>Due Date</b>	11/30/2005	<b>Qty:</b>	3
<b>Previous Run</b>				<b>Um:</b>	Each		
<b>Written By</b>							
<b>Checked &amp; Approved By</b>							
<b>Comment</b>	Est. C 05.03.10    Removed P/O for liquid penetrant inspection    K J/JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T5000W125	6061-T6 Tube 5.00X.125W	
		Comment: Qty.: 0.9406 f(s)/Unit Total : 2.8218 f(s) Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall( M6061T6T5.000W.125) Batch: _____	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut D3262-1 to length as per Dwg D3262 Identify as D3262-1	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

Date: Monday, 12/12/2005 8:31:55 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 23284A

Part Number: D32621

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Ensure to mask threads

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Monday, 12/12/2005 8:31:58 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: FUEL PURGE CANISTER		
<b>Job Number</b>	23284B			<b>Part Number</b>	: D32623		
<b>Estimate Number</b>	10442			<b>Drawing Number</b>	: D3262 REV B		
<b>P.O. Number</b>	:			<b>Project Number</b>	:		
<b>This Issue</b>	12/12/2005 <b>S.O. No.</b> :			<b>Drawing Revision</b>	: B		
<b>Prsht Rev.</b>	NC			<b>Material</b>	:		
<b>First Issue</b>	11/14/2005 <b>Type</b> : MACHINED PARTS			<b>Due Date</b>	: 11/30/2005 <b>Qty:</b> 6 <b>Um:</b> Each		
<b>Previous Run</b>	:						
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	:						
<b>Comment</b>	: Est. C 05.03.10    Removed P/O for liquid penetrant inspection K J/JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"	
		<b>Comment:</b> Qty.: 0.9668 f(s)/Unit   Total : 5.8010 f(s) Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B0.500x06.000) Batch:	
2.0	BAND SAW	BAND SAW	
		<b>Comment:</b> BAND SAW Cut blanks: 6.000" x 0.500" x 5.400" long Bar Machine as per Folio FA457 and Dwg D3262 Identify for D3262-3 Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<b>Comment:</b> SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		<b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

Date: Monday, 12/12/2005 8:31:59 AM

User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 23284B

Part Number: D32623

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Ensure to mask threads

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

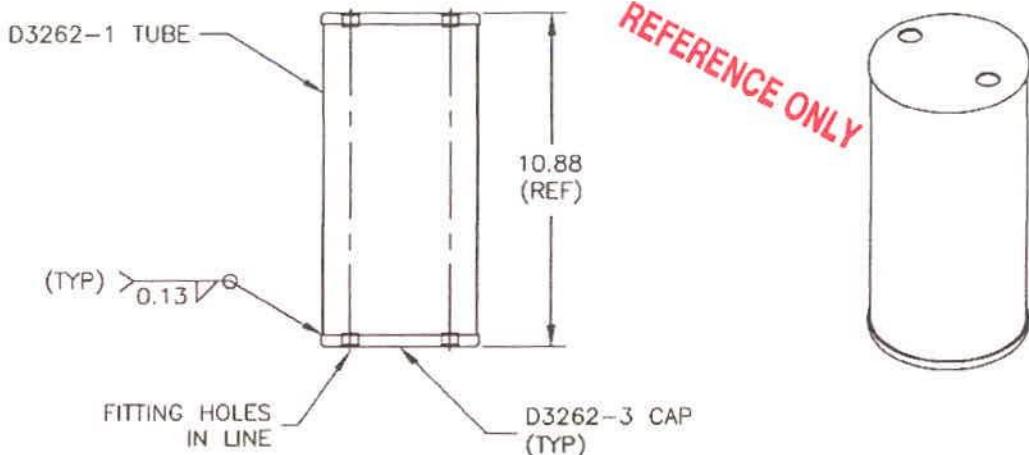
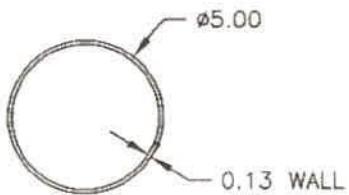
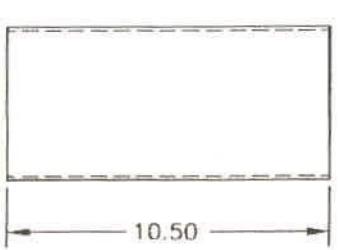
Inspection Level 21

Job Completion



**DART**

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3262	REV. B SHEET 1 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	

**RELEASED**  
05.02.14 *#***D3262-041 CANISTER ASSEMBLY****D3262-1 TUBE****D3262-041:**

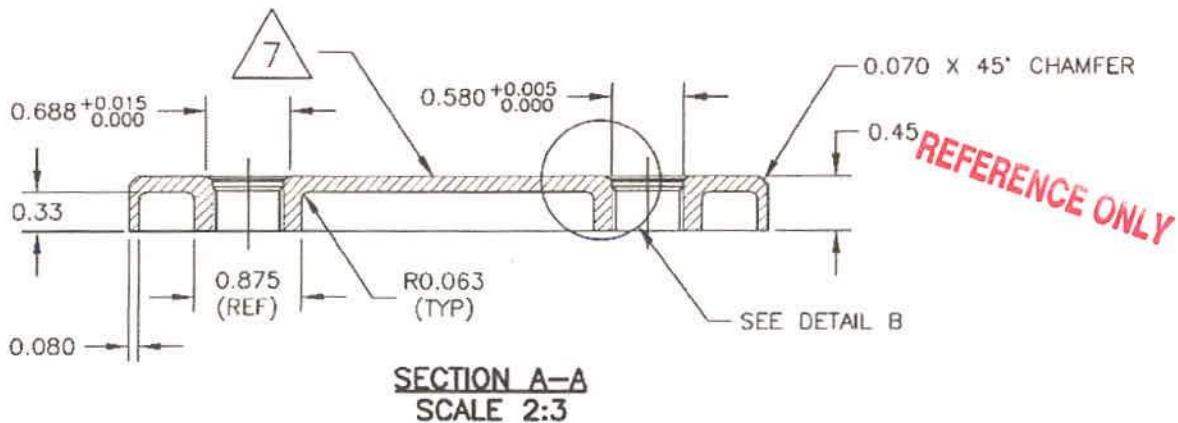
- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)  
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi  
AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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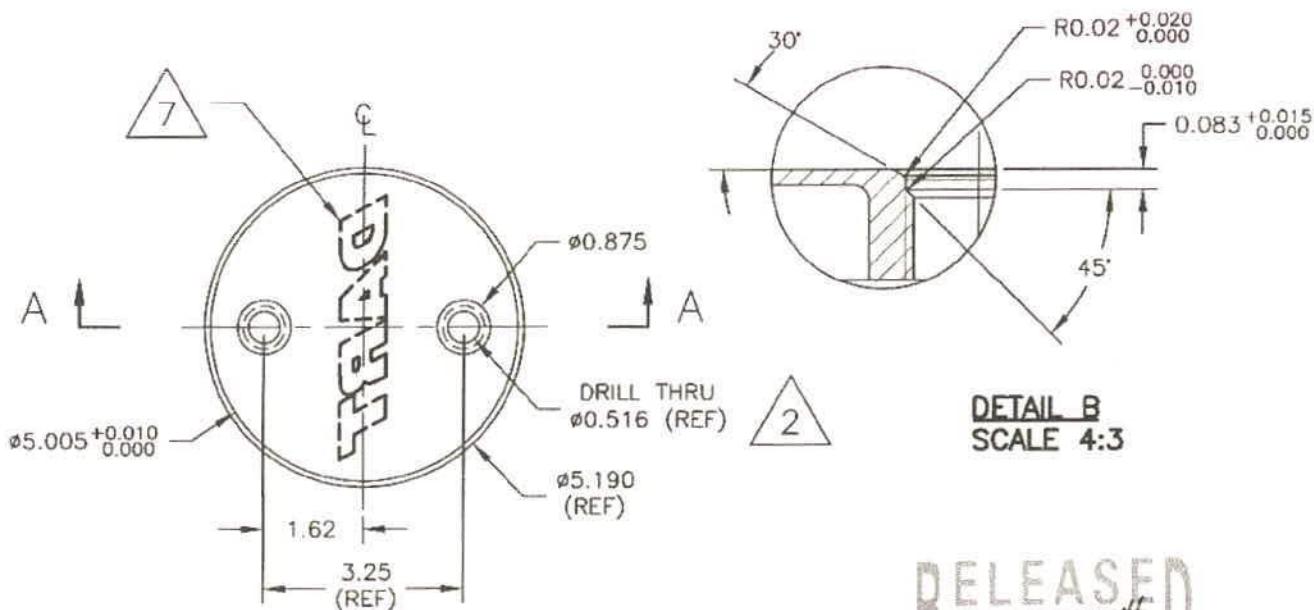
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OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3262	REV. B SHEET 2 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:3



**SECTION A-A**  
SCALE 2:3



RELEASED  
05.02.14 *[initials]*

D3262-3

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP  
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

## Job Costing Report

✓ B

Dart Aerospace Ltd.  
HawkesburyNov 08, 2005  
10:27 am

Work Order No : 0023284  
 Project Name : D3262-041  
 Project For : WK525  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3262-041  
 Description : Fuel Purge Canister  
 Manufactured : Yes  
 Amount Req'd : 20  
 Amount Done : 17  
 Start Date : 05-12-05  
 Est Finish Date : 06-23-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd : Part/All Posted to Finished Goods

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Margin : 0.000%  
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	383.11	100.00	383.11	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	82.98	100.00		
Production Cost :	0.00	1586.51	100.00	1544.79	41.72
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	19.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	1969.62	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	1969.62			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	6.00
Profits/(Loss) :	0.00	( -1969.62)

MIS DB  
W/B  
W/B

Date: Monday, 14/11/2005 8:50:14 AM  
 User: Alba Panzuto

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: FUEL PURGE CANISTER		
<b>Job Number</b>	: 23284						
<b>Estimate Number</b>	: 10440						
<b>P.O. Number</b>	:			<b>Part Number</b>	: D3262041		
<b>This Issue</b>	: 14/11/2005 <b>S.O. No.</b> :			<b>Drawing Number</b>	: D3262 REV B		
<b>Prshrt Rev.</b>	: NC			<b>Project Number</b>	:		
<b>First Issue</b>	: / / <b>Type</b> : MACHINED PARTS			<b>Drawing Revision</b>	: B		
<b>Previous Run</b>	:			<b>Material</b>	:		
<b>Written By</b>	:			<b>Due Date</b>	: 30/11/2005 <b>Qty:</b> 3 <b>Um:</b> Each		
<b>Checked &amp; Approved By</b>	:						
<b>Comment</b>	: Est. C 05.03.10    Removed P/O for liquid penetrant inspection K J/JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	23284A	FUEL PURGE CANISTER	
2.0	23284B	FUEL PURGE CANISTER	
3.0	D32621	Tube	
4.0	D32623	Cap	
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
<b>Comment:</b> LARGE FABRICATION RESOURCE 1 Weld canister assembly as per Dwg D3262 using DT8739 to align fillings Pick: Qty Part Number Description Batch A/R Aluminum Rod _____			
6.0	QC5	INSPECT WORK TO CURRENT STEP	
<b>Comment:</b> INSPECT WORK TO CURRENT STEP 1-Inspect weld and work to Step 8 2-Pressurize canister to 10 psi and submerge under water and check for leaks as per Dwg D3262.			
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
<b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1			

Date: Monday, 14/11/2005 8:50:14 AM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 23284

Part Number: D3262041

Job Number:



Seq. #: Machine Or Operation:

Description :

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Monday, 14/11/2005 8:50:16 AM  
 User: Alba Panzuto

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FUEL PURGE CANISTER		
Job Number	: 23284A						
Estimate Number	: 10441						
P.O. Number	:			Part Number	: D32621		
This Issue	: 14/11/2005 S.O. No. :			Drawing Number	: D3262 REV B		
Prsht Rev.	: NC			Project Number	:		
First Issue	: / / Type : MACHINED PARTS			Drawing Revision	: B		
Previous Run	:			Material	:		
Written By	:			Due Date	: 30/11/2005 Qty: 3 Um: Each		
Checked & Approved By	:						
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T5000W125	6061-T6 Tube 5.00X.125W
2.0	BAND SAW	BAND SAW
<b>Comment: BAND SAW</b> Cut D3262-1 to length as per Dwg D3262 Identify as D3262-1		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</b>		
4.0	QC8	SECOND CHECK
<b>Comment: SECOND CHECK</b>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<b>Comment: HAND FINISHING RESOURCE #1</b> Chemical Conversion Coat as per QSI 005 4.1		
6.0	POWDER COATING	POWDER COATING
<b>Comment: POWDER COATING</b> Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 Ensure to mask threads		

Date: Monday, 14/11/2005 8:50:16 AM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 23284A

Part Number: D32621

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

9.0 DC

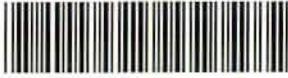
DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Monday, 14/11/2005 8:50:18 AM  
 User: Alba Panzuto

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FUEL PURGE CANISTER		
Job Number	: 23284B			Part Number	: D32623		
Estimate Number	: 10442			Drawing Number	: D3262 REV B		
P.O. Number	:			Project Number	:		
This Issue	: 14/11/2005 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 30/11/2005 Qty: 6 Um: Each		
Previous Run	:						
Written By	:						
Checked & Approved By	:						
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"	
2.0	BAND SAW	BAND SAW	
	Comment: BAND SAW	Cut blanks: 6.000" x 0.500" x 5.400" long Bar Machine as per Folio FA457 and Dwg D3262 Identify for D3262-3 Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
	Comment: HAND FINISHING RESOURCE #1	Chemical Conversion Coat as per QSI 005 4.1	
6.0	POWDER COATING	POWDER COATING	
	Comment: POWDER COATING	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 Ensure to mask threads	

Date: Monday, 14/11/2005 8:50:18 AM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 23284B

Part Number: D32623

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

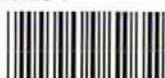
INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

